

# Work Order ID 65563

January 19, 2011 1:51:39 PM

*June only*



Page 1

Item ID: D2362-3	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Support Bracket					
Start Date: 1/20/11	Start Qty: 6.00		Cust Item ID:		
Required Date: 5/03/11	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan: <i>WTF</i>	Date: 11-01-19	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2362	Rev E1								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
HAAS CNC vertical machine #1	Memo 1- Mill as per Folio FA800 Rev: _____ & Dwg D2362 Rev: _____ per dwg D2362	0.00							
		<i>SA 11/2/8</i>							
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
		<i>SA 11/2/8</i>							
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							
		<i>OK 11/02/08</i>							

*9*

*9*

*9*

# Work Order ID 65563

January 19, 2011 1:51:39 PM



Page 2

Item ID: D2362-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Bracket

Start Date: 1/20/11 Start Qty: 6.00



Cust Item ID:

Required Date: 5/03/11 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:55								
	320° FINISH TIME: 9:25								
150	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

SA 11/2/7

M 115951

9 BP 11-02-8.

9 d M 11/02/09

# Work Order ID 65563



Page 3

January 19, 2011 1:51:40 PM

Item ID: D2362-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Bracket

Start Date: 1/20/11 Start Qty: 6.00



Cust Item ID:

Required Date: 5/03/11 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Bond rubber D2397-1 followed by D2397-3 using contact cement as per Dwg D2362 Batch 4111045								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
180 	Identify as per dwg & Stock Location: 478	0.00							
Packaging	Memo	0.00							
Packaging									

454/02/09 (9)

SB 1160269

(9)

11/21/10 (9x)

**Work Order ID 65563**

Page 4

January 19, 2011 1:51:40 PM

Item ID: D2362-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Bracket

Start Date: 1/20/11 Start Qty: 6.00



Cust Item ID:

Required Date: 5/03/11 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

U 1102-10

# Picklist Print

January 19, 2011 1:51:38 PM

Page 1

Work Order ID: 65563

Parent Item: D2362-3

Parent Item Name: Support Bracket



Start Date: 1/20/11

Required Date: 5/03/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: G000.05.18 Added inspection level 8 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2265		Manufactured	No			160	Each	132.0000	1	6			
Step Bracket													

Location	Loc Qty	Loc Code
ST482	132	
37477	38	
44114	94	

D2397-1		Manufactured	No			160	Each	11.0000	1	6			
Rubber Cushion													

Location	Loc Qty	Loc Code
ST013	11	
38053	11	

D2397-3		Manufactured	No			100	Each	10.0000	1	6			
Rubber Cushion													

Location	Loc Qty	Loc Code
ST013	10	
38054	10	



**DART**



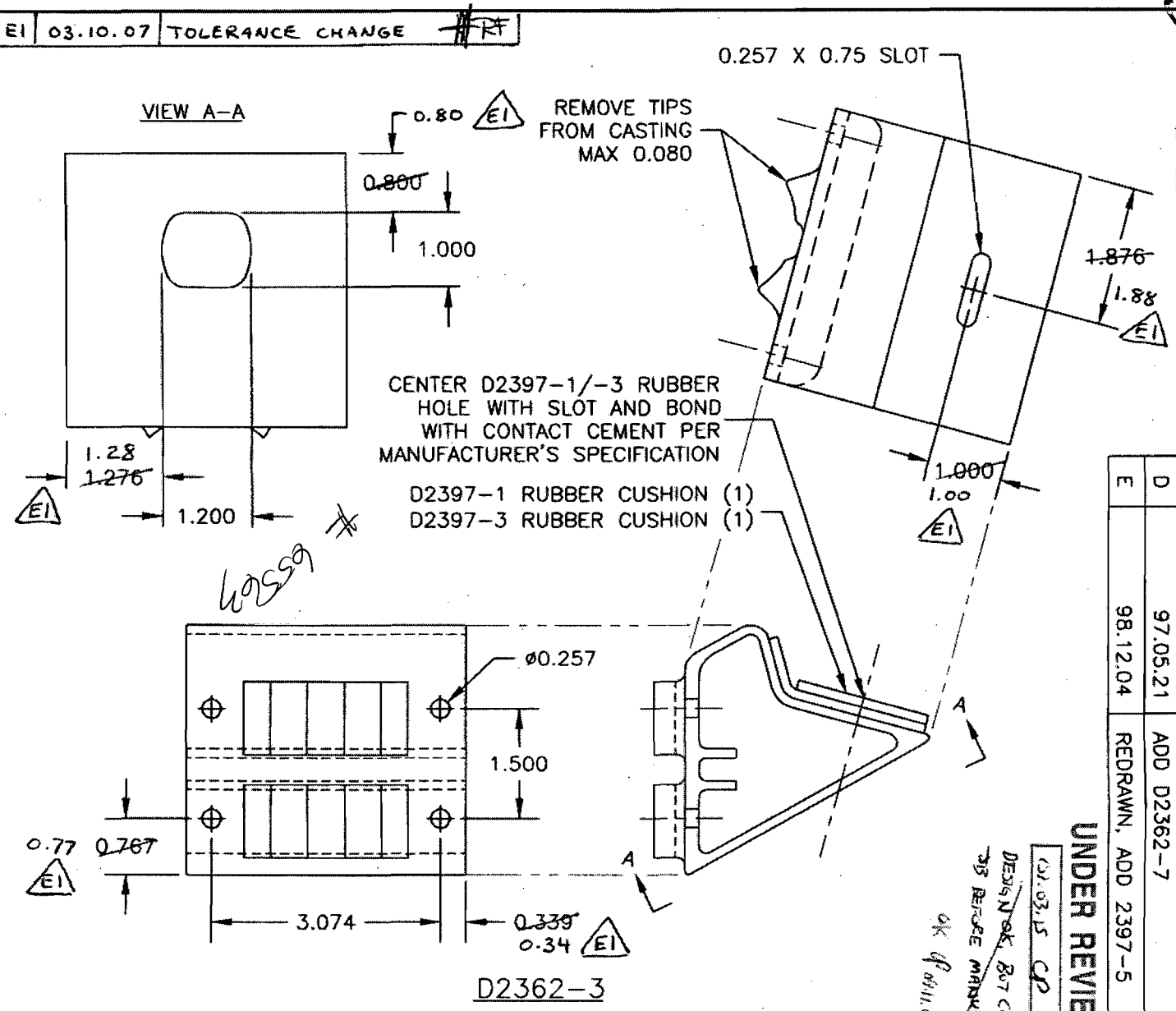
**RELEASED**  
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	REV. E
BW	<i>CP</i>		
CHECKED KE	APPROVED #	DRAWING NO. D2362	SHEET 1 OF 3
DATE 98.12.04		TITLE STEP SUPPORT BRACKET	SCALE 1:2
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

**UNDER REVIEW**

01.03.15 CP

DESIGN OK, BUT CHECK WITH  
3B BEFORE MANUFACTURE  
OK 01/04/09



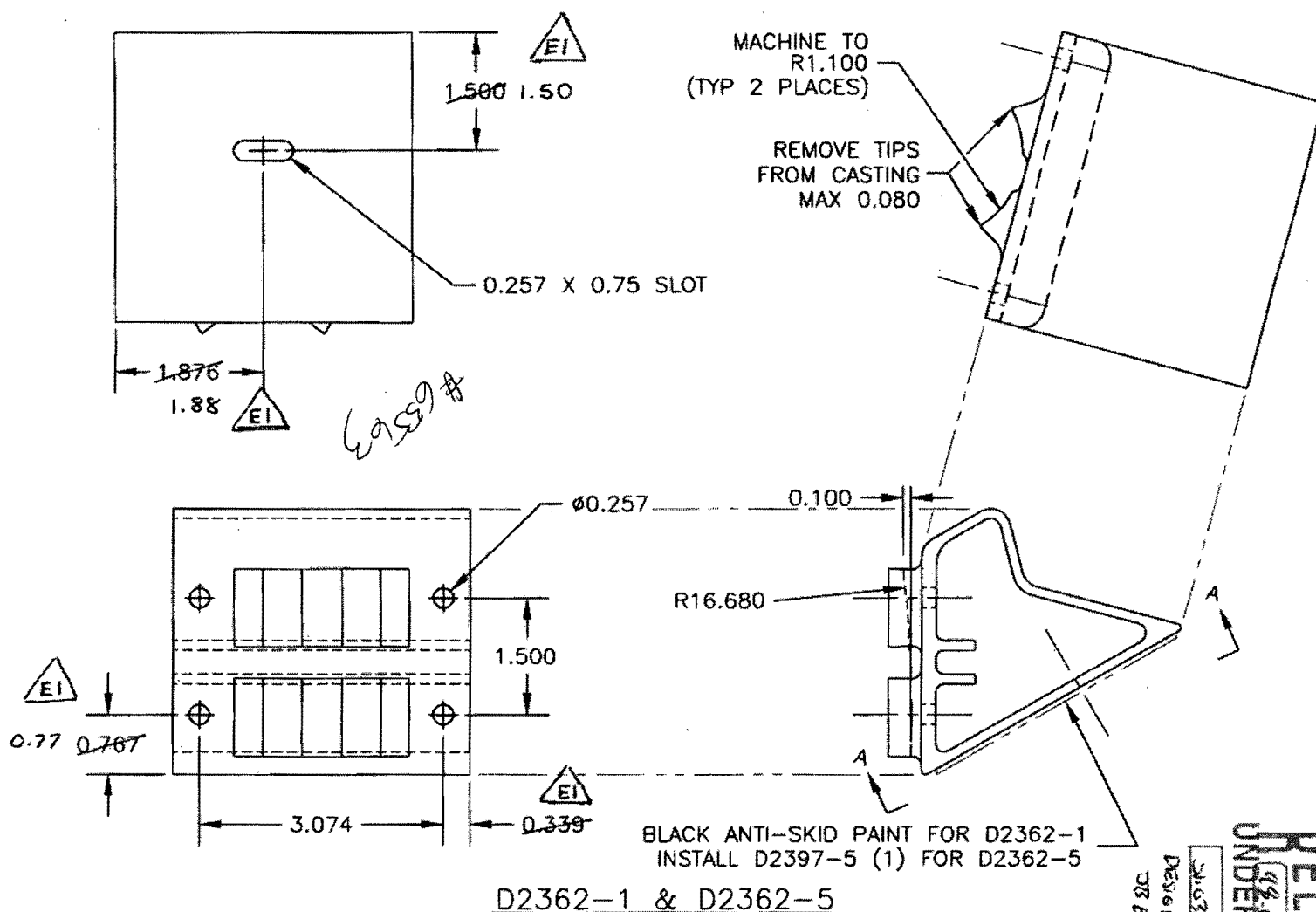
**NOTES:**  
MAKE FROM D2265  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING  
RUBBER IN PLACE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	KE	APPROVED	JP	HAWKSBURY, ONTARIO, CANADA
DATE	98.12.04	DRAWING NO.	D2362	REV. E
		TITLE	STEP SUPPORT BRACKET	SHEET 2 OF 3
		SCALE	1:2	

VIEW A-A



**NOTES:**

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
98.12.14  
UNDER REVIEW

DESIGNED BY: J. B. B. L. W.  
OR BEFORE MANUFACTURE  
OK 98.12.09



**DART**



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2362
DATE	TITLE	SHEET 3 OF 3
98.12.04	STEP SUPPORT BRACKET	SCALE
		1:2

UNDER REVIEW

010315 CP  
DESIGN ON BUT CHECK WITH  
DTS BEFORE MANUFACTURE

RELEASED  
98.12.14 KE

D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED

